

**Work Order ID 111861**

Thursday, January 23, 2014 4:11:34 PM

**\*111861\***

Page 1

Item ID: D4634-143

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Middle, Center Ceiling Replacement Panel Assembly

Start Date: 1/23/2014 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 1/28/2014 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: 1/1 Date: 1/20/23 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4634	E								

100

0.00

**\*100\***

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Pick Kit

① SAD 14/01/27

110

0.00

**\*110\***

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D4634-143 Scotch-Weld 1300L BFI m1279131- Locate and glue down Channel Assy, angles, brackets, and mounting pads  
using 3M Plastic welder II.Batch # m127913Expiry Date 7/10/20142- Apply labels as per Dwg. and seal with 3M 3950 edge sealer BFI m12725① SAD 14/01/27

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Page 2

Item ID: D4634-143 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Middle, Center Ceiling Replacement Panel Assembly  
Start Date: 1/23/2014 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 1/28/2014 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC6- Inspect dimensions to drawing  Memo	0.00 Shp 14/1/28				1			
125 <b>*125*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 Shp 14/1/28				1			
130 <b>*130*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>Mal Fab</u>  Memo	0.00 0.00				0	SAP	14/01/28	

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**\*1 1 1 861\***

Page 3

**Accept**

**\*N900040100\***

**Setup Start \*NS1\***

Revision ID:

**Item Name:** Middle, Center Ceiling Replacement Panel Assembly

Stop \*NS2\*

**Start Date:** 1/23/2014      **Start Qty:** 1.00      **\*1\***

**Cust Item ID:**

**Required Date:** 1/28/2014      **Req'd Qty:** 1.00      **\*1\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/  
Work Center ID

### Operation Description

### Set Up/ Run Hours

**Tool ID**

Tool #

**Plan  
Code**

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

## Memo

0.00

## Quality Control

MCJ 14-01-25

14-01-28

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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01  
016  
0160000

1000000

1000000

# Picklist Print

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Page 1

Work Order ID: 111861

**\*111861\***

Parent Item: D4634-143

**\*D4634-143\***

Parent Item Name: Middle, Center Ceiling Replacement Panel Assembly

Start Date: 1/23/2014

Required Date: 1/28/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A New Issue 13/02/05 DL VERIFIED BY:JLM IPP Rev.  
B Dwg. Update 13/07/09 DL verf: DD IPP Rev. C Dwg  
Update remove channels add foam 13/12/23 DL IPP REV D. 14/01/20 Dwg  
Update DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4647-1

Manufactured No

100

Each

13.0000

1

1

**\*D4647-1\***

Doubler

\*\*

SAD 14/01/27

Location

Loc Qty

Loc Code

ST116

13

104796

6

111234

5

95871

2

D5021-3

Manufactured No

100

Each

1.0000

1

1

**\*D5021-3\***

Foam, Center Panel, Middle

\*\*

SAD 14/01/27

Location

Loc Qty

Loc Code

prelim

1

111351

1

MS20426AD3-4

Purchased No

100

Each

10,559.00

4

4

**\*MS20426AD3-4\***

RIVET

\*\*

SAD 14/01/27

Location

Loc Qty

Loc Code

ST334

4000

m127432

4000

ST509

6559

125578

6559

4

# Picklist Print

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Page 2

Work Order ID: 111861

**\*111861\***

Parent Item: D4634-143

**\*D4634-143\***

Parent Item Name: Middle, Center Ceiling Replacement Panel Assembly

Start Date: 1/23/2014

Required Date: 1/28/2014

Start Qty: 1.00

Required Qty: 1.00

MS20426AD4-6

Purchased

No

100

Each

3,086.000

4

4

**\*MS20426AD4-6\***

Rivet

\*\*

SAD 14/01/27

Location

Loc Qty

Loc Code

GA

1582

m126474

1582

ST334

1504

124392

1504

MS21059L08

Purchased

No

100

Each

1,112.000

2

2

**\*MS21059L08\***

Nut

\*\*

SAD 14/01/27

Location

Loc Qty

Loc Code

ST508

1112

125654

1112

D4634-3

Manufactured

No

100

Each

0.0000

1

1

**\*D4634-3\***

Middle, Center Ceiling Panel

B111165

\*\*

SAD 14/01/27

D4636-5

Manufactured

No

100

Each

36.0000

1

1

**\*D4636-5\***

Bracket

\*\*

SAD 14/01/27

Location

Loc Qty

Loc Code

ST115

36

111230

36

D4664-5

Manufactured

No

100

Each

64.0000

6

6

**\*D4664-5\***

Spacer

\*\*

SAD 14/01/27

Location

Loc Qty

Loc Code

prelim

64

111711

64

6

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Shop Packet Print

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**Picklist Print**

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Work Order ID: 111861

**\*111861\***

Parent Item: D4634-143

**\*D4634-143\***

Parent Item Name: Middle, Center Ceiling Replacement Panel Assembly

Start Date: 1/23/2014

Required Date: 1/28/2014

Start Qty: 1.00

Required Qty: 1.00

D4712-1

Manufactured No

100

Each

10.0000

2

2

**\*D4712-1\***

Bracket

\*\*

SAD 14/01/27

LocationLoc QtyLoc Code

prelim

2

110411

2

ST121

8

111162

8

D4732-21

Manufactured No

100

Each

20.0000

1

1

**\*D4732-21\***

Label

\*\*

SAD 14/01/28

LocationLoc QtyLoc Code

ST122

20

111249

16

93173

4

D4732-25

Manufactured No

100

Each

23.0000

1

1

**\*D4732-25\***

Label

\*\*

SAD 14/01/28

LocationLoc QtyLoc Code

ST122

23

111251

16

93234

7

MPNY-750S-9-C

Purchased No

100

Each

957.0000

3

3

**\*MPNY-750S-9-C\***

Mounting Pad

\*\*

SAD 14/01/28

LocationLoc QtyLoc Code

ST390

957

124058

1

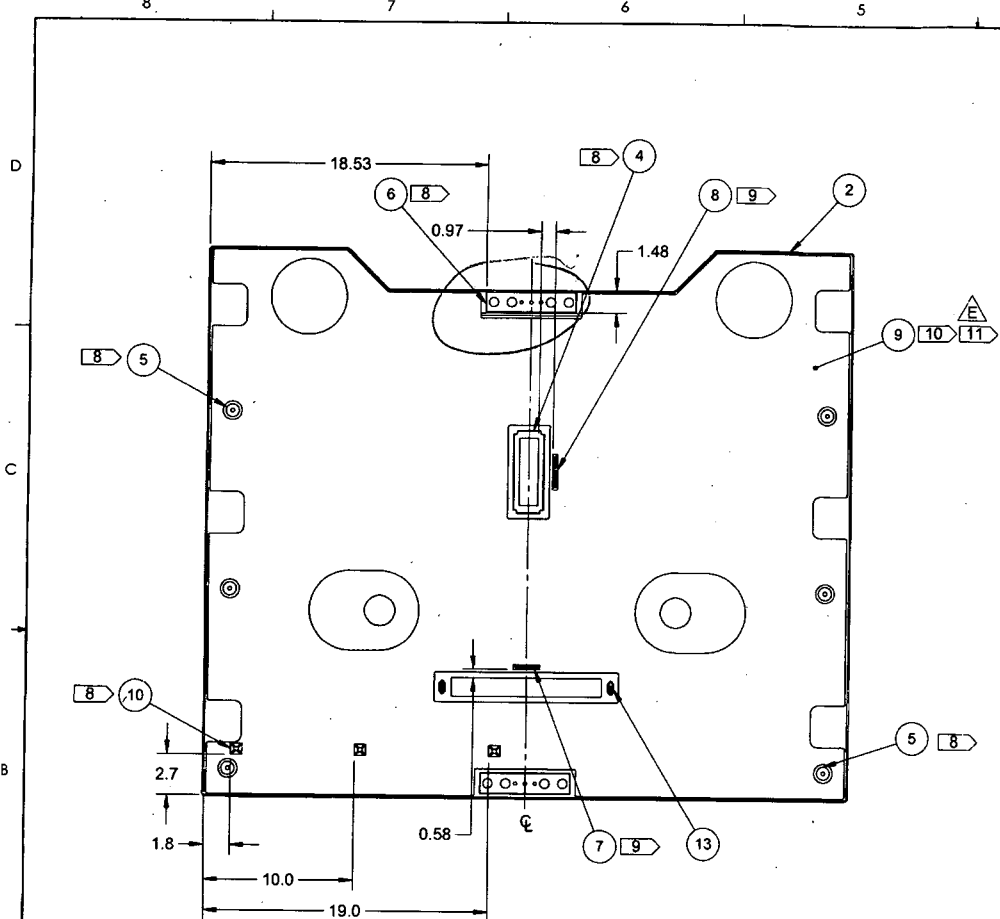
M127960

956





111861 14-01-23

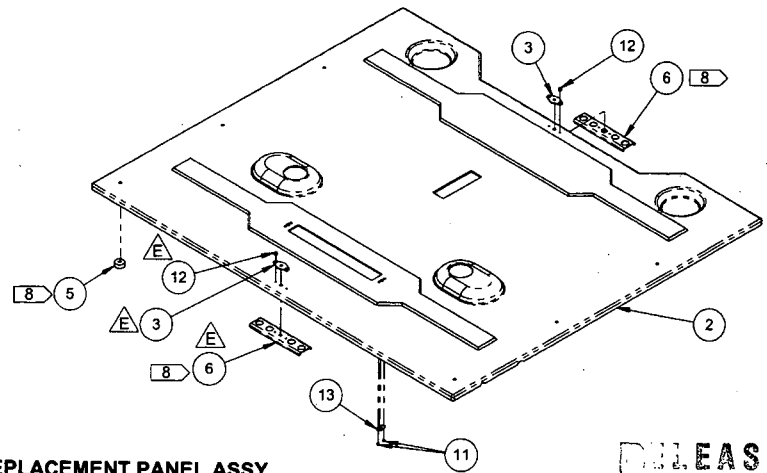


**D4634-143 MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4647-1, D4664-5 & MPNY-750S-9C. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE. LOCATE D4647-1 IN LINE WITH RECTANGULAR OPENING
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO BOND D5021-3 FOAM CORE TO INSIDE OF PANEL
- 11) CENTER D5021-3 FOAM ON D4634-3

ITEM NO.	QTY. -143	PART NUMBER	DESCRIPTION
1	X	D4634-143	MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY
2	1	D4634-3	MIDDLE, CENTER CEILING PANEL
3	2	D4636-5	BRACKET
4	1	D4647-1	DOUBLER
5	6	D4664-5	SPACER
6	2	D4712-1	BRACKET
7	1	D4732-21	LABEL
8	1	D4732-25	LABEL
9	1	D5021-3	FOAM, CENTER PANEL, MIDDLE
10	3	MPNY-750S-9-C	MOUNTING PAD
11	4	MS20426AD3-(4)	RIVET
12	4	MS20426AD4-(6)	RIVET
13	2	MS21059L08	ANCHOR NUT



RELEASED  
2014-01-22  
MO

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. E
MFG. APPR.	AL	D4634	SHEET 8 OF 17
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	CENTER CEILING PANELS	NTS
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